

Work Order ID 109965

109965

Page 1

December-10-13 7:10:45 AM

Item ID: D4450-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm
 Start Date: 12/10/13 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 12/11/13 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: V Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4450	A								
100	Small Fab	0.00							FF
100						3			13-12-10
Small Fab	Memo	0.00							
Small Fab	1- punch one side 2- bend as per dwg 3- drill holes as per dwg USING DT9946 4- deburr								
			DAS 27 9-89						
110	QC5- Inspect part completeness to step on W/O	0.00							
110			13/12/10			3			
QC	Memo	0.00							
Quality Control									
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
120			11/12/6878			3	φ	13-12-11	DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:15. OVEN TEMPERATURE: 320 FINISH TIME: 11:45.								

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109965

Page 2

Item ID: D4450-1

Accept

N19000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 12/10/13 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 12/11/13 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00				3			
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
32
9-89

13/12/16 (3)

[Signature] 13/12/18
mf
13-12-18

Picklist Print

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Work Order ID: 109965

Parent Item: D4450-1

Parent Item Name: Arm

Start Date: 12/10/13

Required Date: 12/11/13

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 11.11.14 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049 304 RD Tube .500 x .049W		Purchased	No			100	f	212.4591	2.3	8		FF 12-12-10	

Location

Loc Qty

Loc Code

MAT017

212.459116

119087

0.000016

120633

43.66

123449

84.0547

125513

24.534

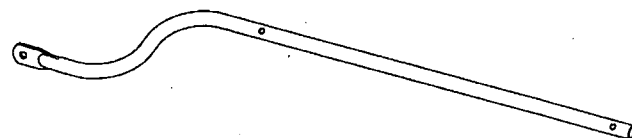
m126466

60.2104

8

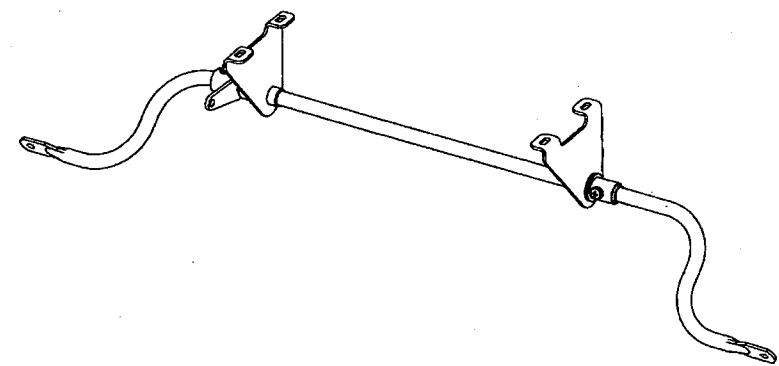
8 7 6 5 4 3 2 1

D



D4450-1 ARM

C



D4450-043 ARM

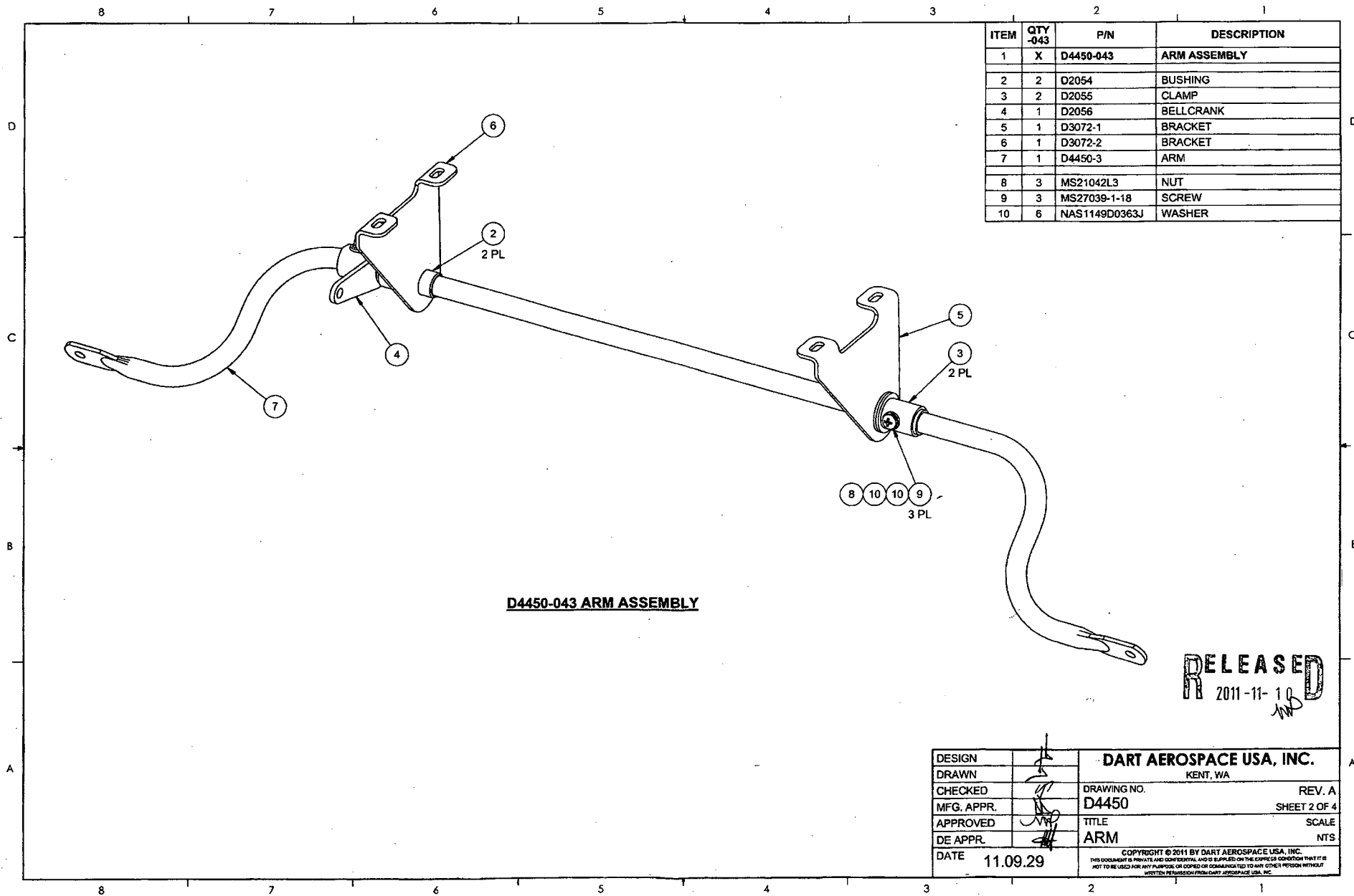
B

A

8 7 6 5 4 3 2 1

RELEASED
2011-11-10
MD

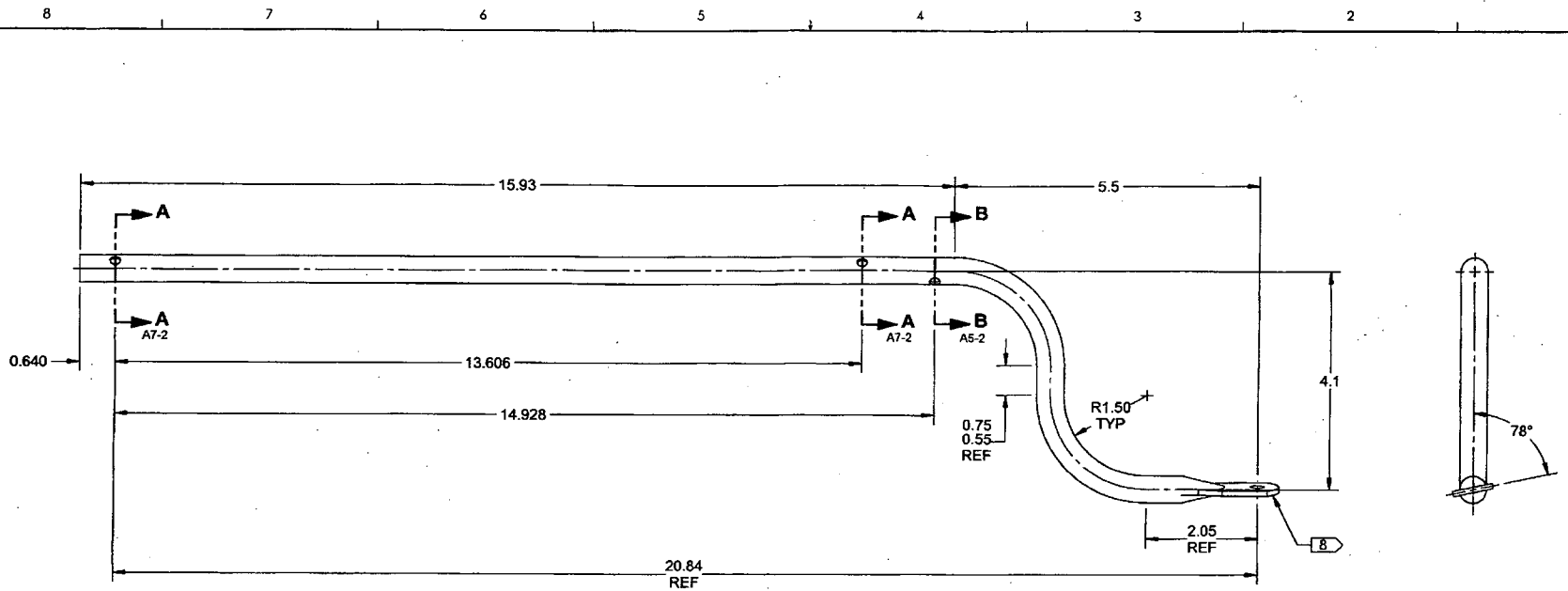
A	NEW ISSUE	MB	11.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4450 TITLE ARM	REV. A	SHEET 1 OF 4
DRAWN		SCALE	NTS
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.09.29	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



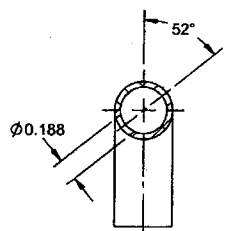
ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4450-043	ARM ASSEMBLY
2	2	D2054	BUSHING
3	2	D2055	CLAMP
4	1	D2056	BELLCRANK
5	1	D3072-1	BRACKET
6	1	D3072-2	BRACKET
7	1	D4450-3	ARM
8	3	MS21042L3	NUT
9	3	MS27039-1-18	SCREW
10	6	NAS1149D0363J	WASHER

RELEASED
2011-11-10

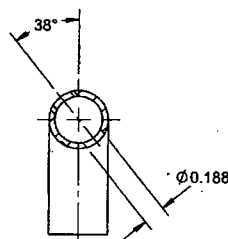
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4450	SHEET 2 OF 4
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DE APPR.		ARM	NTS
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D4450-1 ARM



SECTION A-A
SCALE 2X
C4-2
C8-2



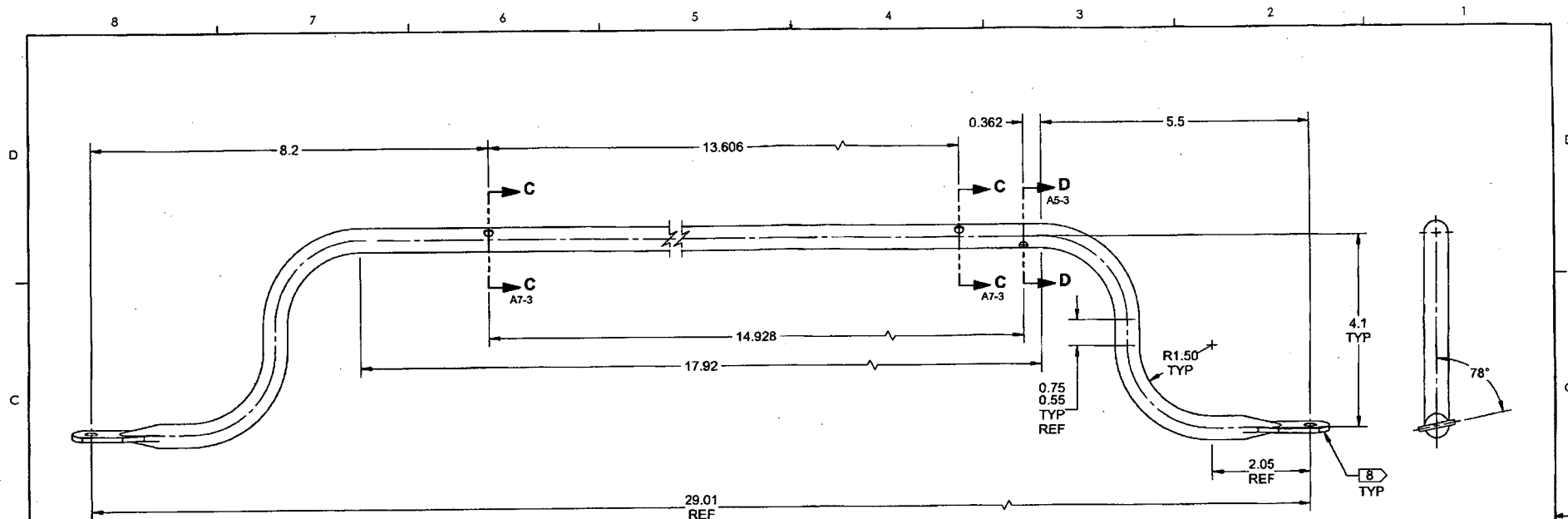
SECTION B-B
SCALE 2X
C4-2

D4450-1 NOTES:

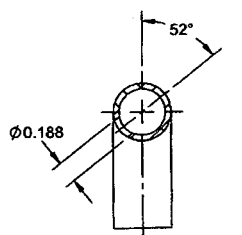
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.50 \times 0.049$ WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 REF. DART SPEC. M304TR0.500W.049
- 2) FINISH: POWDER COAT "BLACK SANDETEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs
- 8) PUNCH END PER SPEC. CONTROL DRAWING D2727

RELEASED
2011-11-18

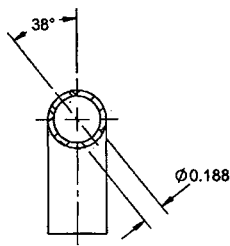
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D4450-3 ARM



SECTION C-C
SCALE 2X
C4-3
C6-3



SECTION D-D
SCALE 2X
D3-3

D4450-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\varnothing 0.50 \times 0.049$ WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION NONE
- 7) WEIGHT: 0.72 lbs
- 8) PUNCH END PER SPEC. CONTROL DRAWING D2727
- 9) REFER TO SHEET 2, D4450-043 ARM ASSEMBLY, FOR INSTALLATION OF REQUIRED PARTS PRIOR TO PERFORMING ALL BENDS

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2011-11-10

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CHECKED		DRAWING NO.	REV. A
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